

DB 241 560 A 1

Abstract

(54) Device for forming profiled marginal outlines on prefabricated sheet metal hollow parts

(57) The invention relates to a device for forming profiled marginal outlines on prefabricated sheet metal hollow parts preferably having been produced by ball flow turning, and is particularly suitable for applying the process according to DD-WP B 21 D /265 209 2. Based on this process where the flange of a sheet metal hollow part being clamped in a fixed manner in a press is at first given an intermediate form corresponding to the marginal outline to be profiled and this through free forming by axial-pressure induced tangential expansion during the press stroke followed by final forming of the marginal outline through further forming of the flange with levelling of the remaining flange either simultaneously or subsequently , the device essentially consists of a counter-pressure punch being supported via compression springs and an ejector being arranged in a relatively flexible axial position and being supported against the counter -pressure punch via further compression springs and of a centrally accomodating marginal outline ring with the marginal outline area and the adjacent levelling area to which a device upper part is also arranged in a relatively flexible axial position.